

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-025353**Date Inspected:** 27-Jul-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site**CWI Name:** Tony Sherwood**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Sections**Summary of Items Observed:**

This Quality Assurance (QA) Inspector, Craig Hager was on site at the job site between the times noted above. This QA Inspector was on site to randomly observe Quality Control (QC) personnel perform Non-Destructive Testing (NDT) and monitor American Bridge/Fluor (ABF) welding operations. This Quality Assurance (QA) Inspector, Craig Hager observed the following.

This QA Inspector met with QA Inspector William Clifford and conducted a walkthrough of the various OBG sections explaining the layout of the QC weld identifications, site specific safety issues and provided various site specific documents.

Orthotropic Bridge Girder (OBG) Sections:

11W/12W-E2: This QA Inspector randomly observed ABF welding personnel Hua Qiang Hwang (#2930) using the Flux Cored Arc Welding (FCAW) process in the vertical (3G) position inside this OBG section. This QA Inspector randomly observed QC Inspector Tony Sherwood verify the following welding parameters; 250 amperes and 24.6 volts at a travel speed of 235 mm per minute to produce a heat input value of 1.57 Kj per mm. The welding observed appeared to comply with ABF-WPS-D15-3042B-1. This QA Inspector periodically observed QC Inspector Tony Sherwood monitoring the work at this location.

11W: This QA Inspector randomly observed ABF welding personnel Xiao Jian Wan (#9677) using the FCAW process to fillet weld various plates of the Catwalk Foundation to the "A" deck at this location. This QA Inspector randomly observed QC Inspector Fred Von Hoff monitoring the welding at this location.

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Summary of Conversations:

This QA Inspector had general conversations with American Bridge/Fluor (ABF) and Caltrans personnel during this shift. Except as described above and noted below there were no notable conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy (510) 385-5910, who represents the Office of Structural Materials for your project.

Inspected By:	Hager,Craig	Quality Assurance Inspector
Reviewed By:	Levell,Bill	QA Reviewer
